

Date: Monday, 12/01/2009 2:36:56 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARSHOE
Job Number :	44657		
Estimate Number :	12788		
P.O. Number :		Part Number :	D356413
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3564 REVD
First Issue :	/ /	Project Number :	N/A
Previous Run :	44007	Drawing Revision :	D
	Type :	Material :	
	SMALL /MED FAB	Due Date :	26/01/2009
Written By :		Qty:	12
		Um:	Each
Checked & Approved By :	<u>JLD 09.01.13</u>		
Comment :	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.2331 sf(s)/Unit Total : 2.7972 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: 110551 IB 9-1-29

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3564
 Dwg Rev: D
 Prog Rev: D

IB 9-1-29

(18)

2-Deburr if necessary

IB 9-1-29

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-1-29

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 09/01/29 (H8)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary A/A

Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8155 N/A

S 09/01/30 (18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:36:57 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 44657

Part Number: D356413

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



09-01-30 (18)



(18)

Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429 N/A

7.0

POWDER COATING

POWDER COATING

m 109648



MD



(18)
09-02-03

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

13:20

OVEN TEMPERATURE:

320°

FINISH TIME:

13:50

FD

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



MD



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-03

(18)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-17

FD 09/02/03

(18)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/04

Job Completion



U 02.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-01-30	5.0 6.0	DT 8155, : joggle comment is not necessary. Remove Perm. Change J.	JJ	09.02.04		JJ 09-01-30	JJ 09-01-30

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-01-30	5.0 6.0							

NOTE: Date & initial all entries



RELEASED

07.09.04 *[Signature]*



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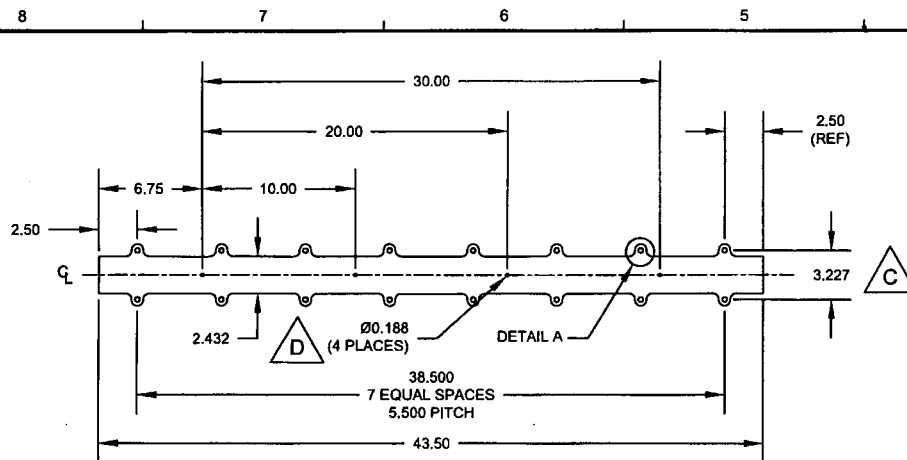
1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)

- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: SEE TABLE IN ZONE A3
8) WELD PER DART QSI 004
9) SEE PG 3 FOR SECTIONS AND DETAILS
10) PARTS ARE SYMMETRIC ABOUT C

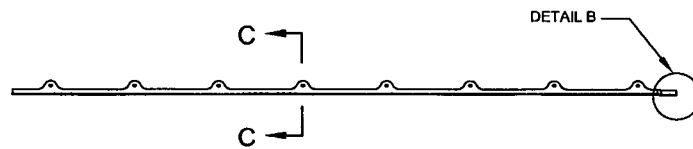
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLCS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7 A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7 A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A		PH	07.04.17
B	ADD AMS 5513 AND AMS 5524		PH	07.03.20
A	NEW ISSUE		PH	06.12.18
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CB			
CHECKED	PH	DRAWING NO.	REV. 0	
MFG. APPR.	PH	D3564	SHEET 1 OF 3	
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DE APPR.	PH	WEARSHOE	1:	
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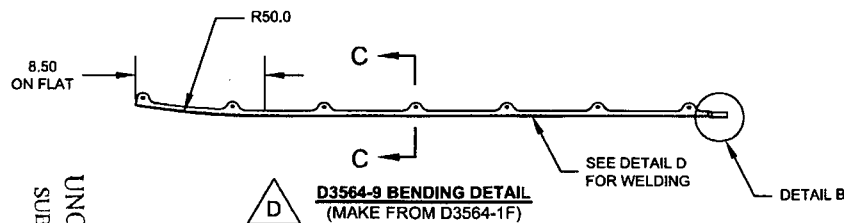
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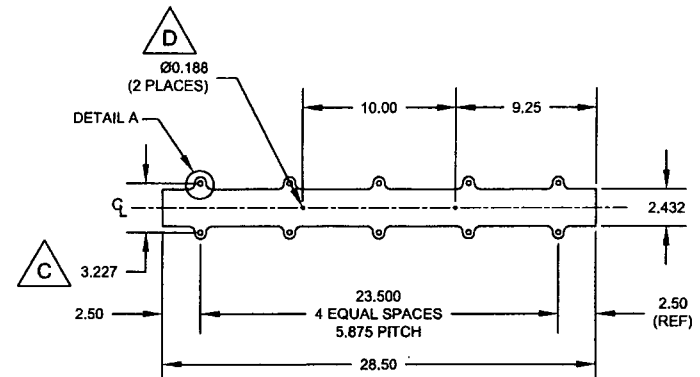
D3564-5F FLAT PATTERN



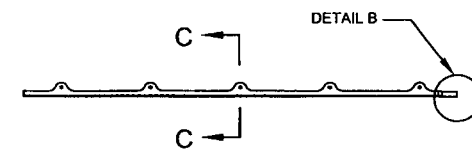
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



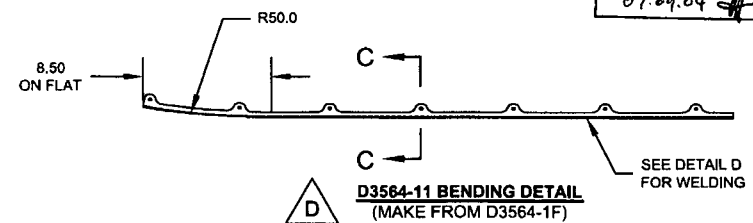
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



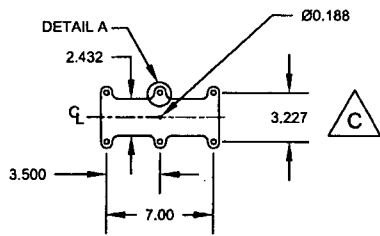
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

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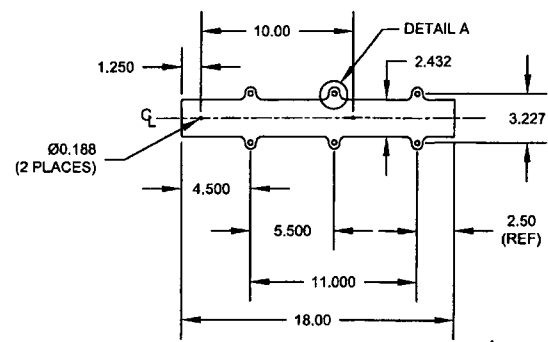
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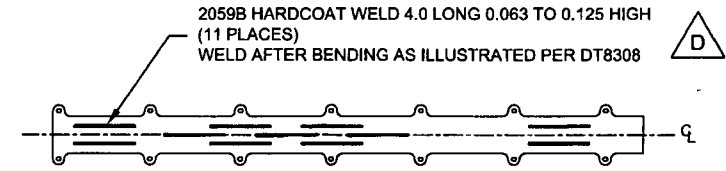
8 7 6 5 4 3 2 1



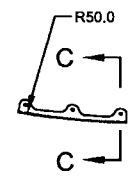
D3564-13F FLAT PATTERN



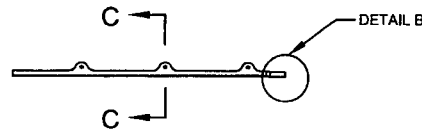
D3564-15F FLAT PATTERN



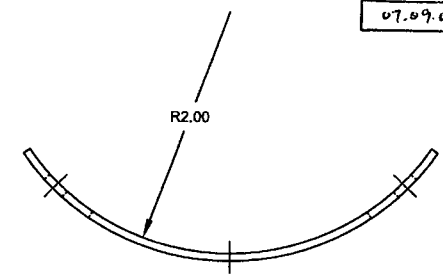
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)

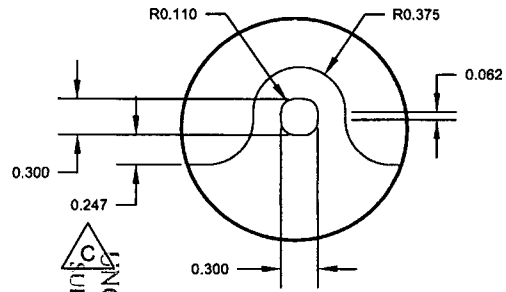


D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

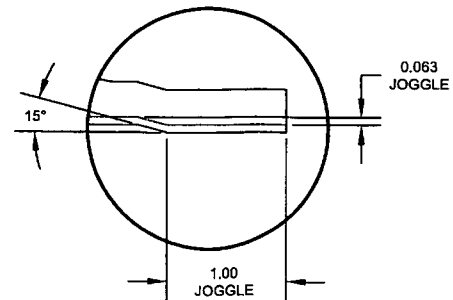


SECTION C-C
SCALE 1:1

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DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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